

Work Order ID 71572

Wednesday, July 06, 2011 1:20:14 PM

*split Blue*

*shg Aug 8*



Page 1

Item ID: D3414-041

Revision ID:

Item Name: Lug Assembly

Start Date: 7/6/2011 Start Qty: 16.00

Required Date: 7/20/2011 Req'd Qty: 16.00

Reference:

Accept



Setup Start



Stop



Cust Item ID:

Customer:

Approvals:

Process Plan:

*CL*

Date: 11/07/06 Tooling:

Date:

QC:

Date: SPC (Y/N):

Date:

Run Start



Stop



Sequence ID/  
Work Center ID

Operation  
Description

Set Up/  
Run Hours

Tool ID

Tool #

Plan  
Code

Accept  
Qty

Reject  
Qty

Reject  
Number

Insp.  
Stamp

Draw Nbr

Revision Nbr

D3414

Rev C

100

0.00



Waterjet

Memo

0.00

FLOW CNC Waterjet

1-Cut as per Dwg D3414-1

Dwg Rev: *C*

Prog Rev: *C*

2-Deburr if necessary

*B 11-7-13*

*(24)*

110

QC2- Inspect parts off machine FAI/FAIB

0.00



QC

Memo

0.00

Quality Control

*B 11-7-13*

# Work Order ID 71572

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Page 2

Item ID: D3414-041

Accept



Setup Start



Revision ID:

Item Name: Lug Assembly

Stop



Start Date: 7/6/2011 Start Qty: 16.00

Required Date: 7/20/2011 Req'd Qty: 16.00



Cust Item ID:

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/  
Work Center ID

Operation  
Description

Set Up/  
Run Hours

Tool ID

Tool #

Plan  
Code

Accept  
Qty

Reject  
Qty

Reject  
Number

Insp.  
Stamp

120

QC8- Inspect parts - second check

0.00



QC

Memo

0.00

SB 11/07/13

Quality Control

counts  
724

130

0.00



Brake NC

Memo

0.00

Brake NC

1-Deburr

2-Form using DT8254 as per Dwg D3414

SB 11/07/14

140

0.00



Large Fab

Memo

0.00

Large Fab

1- Weld using location Jig DT9625 as per Dwg D3414

A/R S.S. welding rod Batch ~~M101872~~

M117659

11-7-08 D

# Work Order ID 71572

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Item ID: D3414-041

Accept



Setup Start



Revision ID:

Stop



Item Name: Lug Assembly

Start Date: 7/6/2011 Start Qty: 16.00



Cust Item ID:

Required Date: 7/20/2011 Req'd Qty: 16.00



Customer:

Reference:

Run Start



Approvals: Process Plan:

Date:

Tooling:

Date:

Stop



QC:

Date:

SPC (Y/N):

Date:

Sequence ID/  
Work Center ID

Operation  
Description

Set Up/  
Run Hours

Tool ID

Tool #

Plan  
Code

Accept  
Qty

Reject  
Qty

Reject  
Number

Insp.  
Stamp

150

QC9- Inspect visual per QSI004- Fusion Welds

0.00



QC

Memo

0.00

Quality Control

11.07.29 (7)

160

QC5- Inspect part completeness to step on W/O

0.00



QC

Memo

0.00

Quality Control

Subtotal

(7)

170

White Gloss(Ref:4.3.5.1) per QSI005 4.3-Alum

0.00



Powdercoat

Memo

0.00

Powder Coating

START TIME: \_\_\_\_\_  
OVEN TEMPERATURE: \_\_\_\_\_  
FINISH TIME: \_\_\_\_\_

AT 11-08-09

175

Spary paint

Prime B 117319  
Defluct Blue B 118395  
Clear B 118053

# Work Order ID 71572

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Item ID: D3414-041

Accept



Setup Start



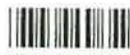
Revision ID:

Item Name: Lug Assembly

Stop



Start Date: 7/6/2011 Start Qty: 16.00



Cust Item ID:

Required Date: 7/20/2011 Req'd Qty: 16.00



Customer:

Reference:

Approvals: Process Plan:

Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/  
Work Center ID

Operation  
Description

Set Up/  
Run Hours

Tool ID

Tool #

Plan  
Code

Accept  
Qty

Reject  
Qty

Reject  
Number

Insp.  
Stamp

180

QC1-Inspect Part Finish

0.00



QC

Memo

0.00

Quality Control

①

11.08.05

190

Identify as per dwg & Stock Location: ST420

0.00



Packaging

Memo

0.00

Packaging

①

JB 11/08/05

200

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

ck 11/08/08

11.08.05  
①



# Picklist Print

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Page 1

Work Order ID: 71572

Parent Item: D3414-041

Parent Item Name: Lug Assembly



Start Date: 7/6/2011

Required Date: 7/20/2011

Start Qty: 16.00

Required Qty: 16.00

Comments: IPP A 05.09.13 New issue KJ/JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M304S12GA		Purchased	No			100	sf	147.3000	0.155	2.48			



304/316 0.100" Sheet

Location	Loc Qty	Loc Code
MAT019	147.3	
113062	118.3	
113077	29	

D3414-3

Manufactured No

140 Each 21.0000



Lug

Location	Loc Qty	Loc Code
WA	21	
69882	21	

70412

x7



B11-7-13

(24)

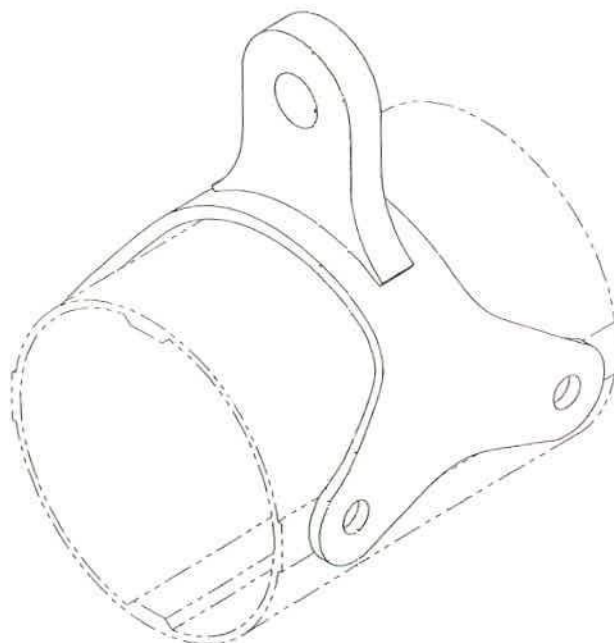
113077

16



EL 11-7-26

ITEM No.	QTY. -041	PART NUMBER	DESCRIPTION
1	X	D3414-041	LUG ASSEMBLY
2	1	D3414-1	LUG BRACKET
3	1	D3414-3	LUG



**D3414-041 LUG ASSEMBLY**

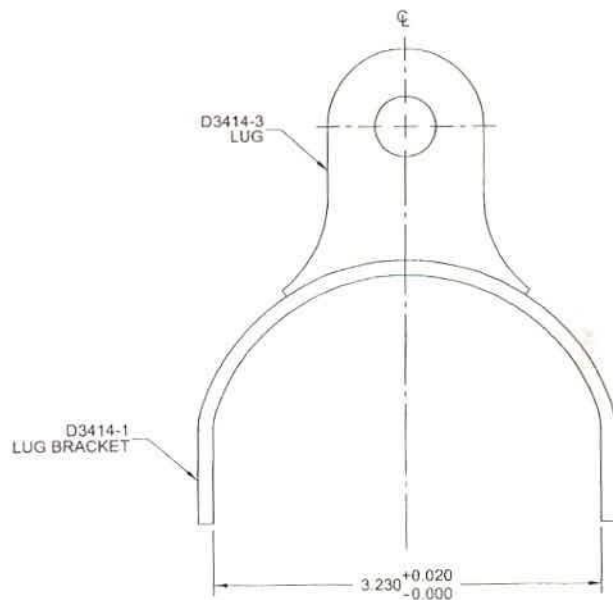
**NOTES:**

- 1) MATERIAL: N/A
- 2) FINISH: POWDER COAT WHITE (4.3.5.2) PER DART QSI 005 4.3
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D3414-041" USING FINE POINT PERMANENT INK MARKER
- 7) WEIGHT: 0.52 lbs

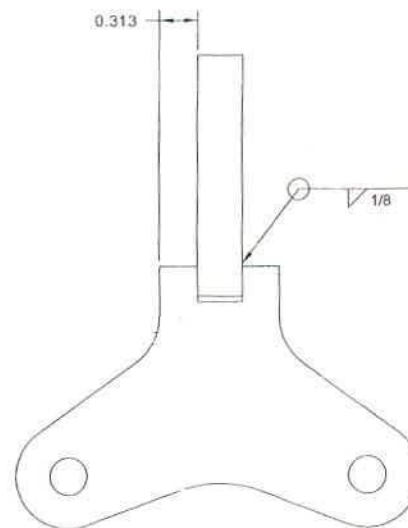
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WITHIN THE  
WORK ORDER  
71572  
CL11107106

**RELEASED**  
3/16/06

C	BREAK SHARP EDGES FOR -3 NOW 0.030-0.060 WAS 0.010-0.030 (ZN A7-3)	CP	09.06.17
B	DRAWING REDRAWN IN SOLIDWORKS WITH CURRENT STANDARDS AND TRANSFERRED TO "B" SIZE BORDER. FLAT PATTERN FOR -1 INCREASED IN LENGTH TO PREVENT FOULING AT INSTL (SEE PAR188). FLAT SPOTS REMOVED FROM -1 (PART NOW "U" SHAPED) FOR EASE OF MANUFACTURE. B7-3 ADDED TOLERANCE TO 3.230 DIM. C2-3 1.12 DIM WAS 1.20.	AJS	08.09.23
A	NEW ISSUE	CP	05.03.16
REV.	DESCRIPTION	BY	DATE
DESIGN	CP	<b>DART AEROSPACE LTD</b> HAWKESBURY, ONTARIO, CANADA	
DRAWN	CP		
CHECKED	CP	DRAWING NO.	REV. C
MFG APPR.	CP	D3414	SHEET 1 OF 3
APPROVED	CP	TITLE	SCALE
DE APPR.	CP	LUG ASSEMBLY	NTS
DATE	09.06.17	COPYRIGHT © 2005 BY DART AEROSPACE LTD THIS DOCUMENT IS UNCLASSIFIED AND IS SUPPLIED ON THE EXPRESS UNDERSTANDING THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR FOR REPRODUCTION IN ANY FORM WITHOUT THE WRITTEN PERMISSION FROM DART AEROSPACE LTD.	



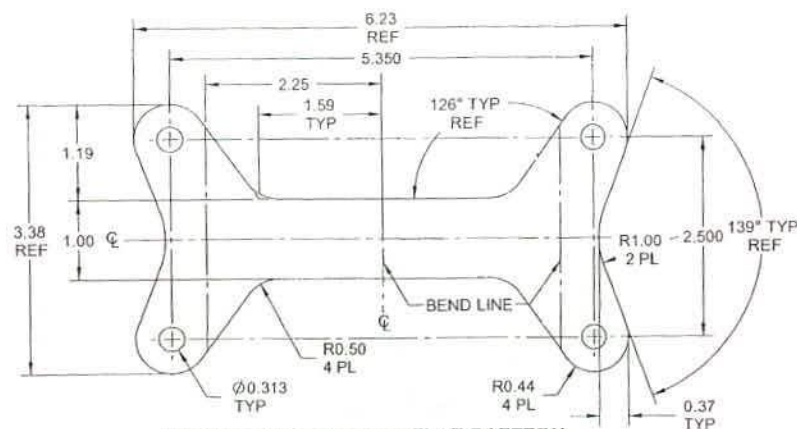
**D3414-041 LUG ASSEMBLY**



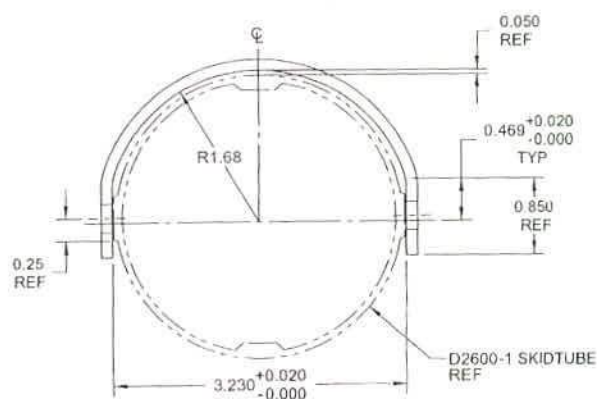
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WORK ORDER  
NO. 71572

**RELEASED**  
*04/18/17*

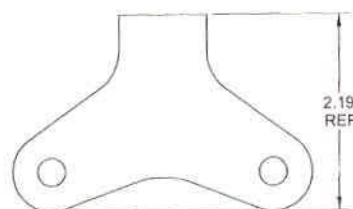
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DRAWN	CP	HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. C
MFG. APPR.		D3414	SHEET 2 OF 3
APPROVED		TITLE	SCALE
DE APPR.		LUG ASSEMBLY	NTS
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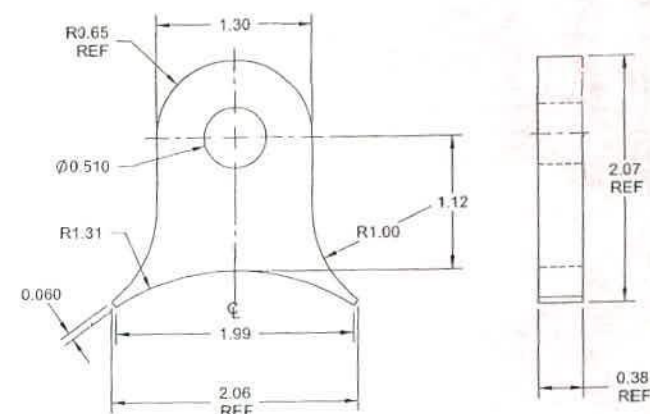
**D3414-1F LUG BRACKET FLAT PATTERN**



**D3414-1 LUG BRACKET**



**SIDE VIEW FOR REF ONLY**



**D3414-3 LUG**

STRICTLY  
RETURN TO  
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SUBJECT TO EXAMINATION  
WITHOUT NOTICE  
WORK ORDER  
NO. 71572

**RELEASED**  
29/10/06

- NOTES:  
1) MATERIAL: -1: AISI 304/316 STAINLESS STEEL SHEET, 12 GAUGE (0.100 THICK)  
PER MIL-S-5059 (ANNEALED) 2B FINISH OR AMS 5513/5524  
REF. DART SPEC. M304S12GA  
-3: AISI 304/316 STAINLESS STEEL PLATE  
PER MIL-S-5059 (ANNEALED) 2B FINISH OR AMS 5513/5524  
REF. DART SPEC. M304S  
2) FINISH: N/A  
3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED  
4) UNITS: INCHES UNLESS OTHERWISE NOTED  
5) BREAK SHARP EDGES: -1: 0.010 TO 0.020 MAX  
-3: 0.030 TO 0.060 MAX  
6) IDENTIFICATION: N/A  
7) WEIGHT: N/A

DESIGN	CP	<b>DART AEROSPACE LTD</b>	
DRAWN	CP	HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. C
MFG. APPR.		D3414	SHEET 3 OF 3
APPROVED		TITLE	SCALE
DE APPR.		LUG ASSEMBLY	NTS
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